

SOUTH PRODUCTION NOTES

**November 12, 2013
Midnight Shift**

**BASF EMPLOYEES
135 Last Recordable
156 Last Lost Time**

#1 MED Clean for AL-4126: Barrel and auger re-assembled. screener was being taken apart...screener and spiral will still need cleaning and screens installed (.156 x 5/16, and 10 mesh).

There is water and oil mixed in green gear box-work order is in.

#1 RC / Clean for AL-4126: Ready. Fire up after starting batches on MED. NOTE: When we start feeding the calciner the first material needs to be drummed off in 2 haz drums, then switch to bags per the MOD

Exhaust to Trimer

Midnight shift notes: No new update(manpower).

Day: Screener cleaned and changed, decision made to Haz Waste first 1-2 drums.

Afternoon: will look at running first batches 11-7 shift. Need to start dryer.

#2 MED line/ Cu-0860: Last raw batch complete. Bodmann would like two trial batches with just wet mix...these will be done first part of Monday afternoon. Waiting on cleaning instructions, Cu-0602 trial to start next week.

#2 RC/ Cu-0860: Continue on. Get surface areas and sample per the MOD.

NOTE: the scale readout in the CRT room not working and the auto valve will not shut off at 1200 lbs. Work note in place, but operators MUST watch the scale when filling and shut off at 1200 lbs (call to CRTs to manually shut off slide gate).

Exhaust to F1

Midnight shift notes:Continued running 3 batches. Found 4 more bags of Cu 3818 in building 7. Need to find more.

Day: Save remaining Cu 3818 for upcoming Cu-0602 trial.

Afternoon: Cleaning instruction will be provided for #2 line after wet mix batches made Monday afternoon. Bodmann's emailed instructions provided to CRTs and operator on 3-11 shift. First wet mix batch made using 3 drums, and only got 2/3 of the batch made. Bodman wants another attempt using 3 drums wet mix during 11-7. If OK, make one more during shift. We will then stop for cleaning on 7-3 shift for Cu-0602 (instruction on GL desk).

Tank 7 / AMT Solution / D-1795: Keep temperatures between 25 and 35 degrees C.

NOTE: The blank has been removed to pump directly from Tank 7 to old pfaudler weigh tank.

Midnight shift notes: Tank level at 40.4%.

Afternoon: Tank level at 29.5%, which is good for 2 batches. Need to make next AMT batch Tuesday morning.

Old Pfaudler D-1795: Goal is to keep the entire pipeline full (totes, hopper, pfaudler, and make sure 7 tank has enough material or make another tank as needed). Continue to write down "dryer feed times" on each batch of totes, and when possible direct feed off of the dryer into the calciner hopper. Only feed into the bag-off from the dryer when necessary.

#3 MED / D-1795 NAQ: Continue to write down "dryer feed times" on each batch of totes, and when possible direct feed off of the dryer into the calciner hopper. Only feed into the bag-off from the dryer if necessary. **DO NOT BUILD FEED!!! KEEP FEEDING THE CALCINER DIRECTLY INTO THE HOPPER. HAVE A BAG HANGING OVER THE HOPPER IN CASE WE ENCOUNTER A GAP IN THE PIPELINE...BUT ALWAYS FEED THE CALCINER.**

#3 RC / D-1795 NAQ: Continue feeding. Watch the feed rate on this calciner! Sample per the MOD. **DO NOT BUILD FEED!!! KEEP FEEDING THE CALCINER DIRECTLY INTO THE HOPPER. HAVE A BAG HANGING OVER THE HOPPER IN CASE WE ENCOUNTER A GAP IN THE PIPELINE...BUT ALWAYS FEED THE CALCINER.**

Exhaust to CTO

Midnight shift notes: Continued to run. 3 bags off on midnight shift.

Day: No issues.

Afternoon: Continue batches and be ready to make next tank on Tuesday morning.

#4 RC / clean for D-5202: Go ahead given to run #4 RC. Due to limitations on Abbe, the decision was made to run remaining clay to make more D-5202.

Exhaust to Trimer

Midnight shift notes: No new update. Engineer to inspect on Monday.

Day: Go ahead given to run RC. Switch to running D-5202.

Afternoon: Lighting calciner and setting up for 5202 (removing drums on discharge).

Check calciner and exhaust routing correctly. Start feeding when ready.

National Dryer / D-5206 : Several Abbe batches made and all were very wet.

Continuing to feed the last of the wet batches....not very fun.

Afternoon: Finished off remaining material in National Dryer hopper. Still have buggy lifted with wet material tha needs to be scraped out into the hopper and fed. Need this done, as Abbe planning to run 11-7 and buggy will be needed later.

PK Blender / AL3917: Blender and building were washed down. Ready to start batches on Monday.

Midnight shift notes: Cleaned on midnight shift. Need to get started Monday if possible.

Day: Cleaning continuing. Need to run pill mix today.

Afternoon: All 25 bags Sterotex made with graphite using lot 8348. Ready to go.

#5 RC / 1506: Stage #1 flowmeter on Trimer repaired, feed restarted Monday early afternoon.

Be advised that we now have the ability to control the feedscrew (on / off) from the CRT room. Feed screw is set at 11Hz with no issues thus far.

Exhaust to Trimer

Midnight shift notes: On hold until trimer stage 1 flow meter is looked at.

Day: Elliott working on Trimer

Afternoon: Restarted 1506 feed, but stopped during shift due to Roton blower blocked up. Check status of roton with Brian Beller (he was working on it). If OK, start feeding again. Looks cleaned up and OK at this time....

New Pfaudler / Celanese Trial: Continue on...batch 9 is currently drying.

Midnight shift update: Batch was made and an additional 68# of water was added to get coverage. The steam is currently on. LOD will need to be checked at 11 am.

Day: Platinum impregnations to start this afternoon.

Afternoon: Continue...currently drying this batch. Follow LOD instructions, as they are different from the other impregnated batches (LOD needs to be below 42%). Check LOD at 1:30 am.

#6 DRYER - RC / Celanese trial: Continue on...it was discovered that the calciner was running in reverse. This has been corrected, and after getting calciner refired we are feeding again at a better rate.

PLEASE NOTE that there was a flame detected inside the calciner from this material exotherming. This is normal, and no changes needed at this time (per Leon Zavodnik). Will reassess in the morning. Do not change feed rate into the calciner until the production team can discuss further.

Only use the square buggies that have been cleaned out and have the "CEHW" label on the side of the buggy.

Exhaust to Sly Scrubber

Midnight shift notes: Continued on feeding at same rate. Material continues to exotherm.

Day: Feed rate to calciner increased

Afternoon: Continue per the MOD/Justin's instructions. Feeding the last of the initial buggies, should go into the morning shift.

Tank 6 / tank rinsed out: Tank is empty. Pump was replaced on Thursday.

Tower 3 / E-406: Continue on. About another 24 hours or so.

Afternoon: no change

Tower 6 / Q-VAM next: Loads 140-5 and 140-6 loaded and running. Next load projected to come down around 7PM....be sure we have the drums, liners and next loads ready.

Midnight shift notes: QVAM adjustments continued and drums for next load have been brought down. Will need to get the next load staged early on 3-11 shift.

Day: Need to stage for next load early next shift

Afternoon: During loading of tower, chain came off of hoist. Still have two bags to load...maintenance assisting at 11:00 pm so last two bags can be loaded.

Harrop Kiln - Al-3921 T 3/16": Continue running. A work notification has been written to have maintenance take a look at the automatic pusher at the cool down zone in the Kiln. It appears as if the clutch is disengaging while pushing carts.

Work notification written for one of the blowers on the kiln (#5 blower stopped working). Still operable, but maintenance needs to see Tower operator for more information.

Make sure pills do not mound in the bag (spread them out and they will fill to the 1500 lb level).

North Screener / Cu-0860: Completed...hold.

South Screener / E-406: Continue E-406.

Midnight shift notes: On hold(manpower).

Day: Working on 1st shift.

Afternoon: Continue on south screener as manpower permits (4 totes to screen).

#2662 Pill Machine / Al-3917 3/16: Was re-assembled, but will not run. Motor hums, then overload light illuminates. Work notification submitted for electrician to service.

#2664 Pill Machine / Al-3917 3/16: Continue on.

Midnight shift notes: Hoppers full and 5 bags of pill mix left until more can be made on the PK blender.

Day: 2662 repair in progress, issue with starter. 2664 continues

Afternoon: 2662 repaired, operator dry ran and now running at end of 3-11 shift. 2664 also running.

HC-11 Tanks / Cu 5020 Strikes: Strikes have been completed. Tanks 2-6 have been cleaned and emptied. Tank 107 is still full of acid water. Will need to communicate with wastewater whether it is ok to send it to them.

Midnight shift notes: Tanks 4,5,6 cleaned.

Day: Tanks inspected. Plan to start 1520 liquids later this week.

Afternoon: Re-rinsing tanks 4 and 6, and flushing/wiping the sample box to remove grit. There is a piece of bag strap in 4 tank. Need to remove so it does not get clogged (check tank). These items supposedly were corrected.

Abbe Blender / D-5206: The abbe lid was opened and the screen reset, then lid resealed. Will need to dry overnight and check for leaks in the morning before using again. Construction will be 1st AND 2nd shift this week. Only run Abbe on 3rd.

Midnight shift notes: Letting lid/screen assembly dry. Need to water test on 1st shift. If it holds, we can continue making batches.

Day: Abbe water tested. OK to go.

Afternoon: no additional work done...should be ready for 11-7 shift.

When we get up and running, drop into the square tote (#3) for feeding the National Dryer. This is the only available National Dryer tote for the 5206 for now (until a few can become available from the Celanese trial), so feed the National Dryer, get #3 tote empty and refill as soon as possible. ALSO, please drain the bottom operated tote as good as possible so that we are not dropping wet material into the National Dryer hopper.

Tunnel Kiln #2 / Set up for Al-3921: Justin provided operators with new instructions for zone temperatures.

Midnight shift notes: Temperatures were adjusted and kiln test cars should be ready to load on 1st shift.

Day/Afternoon: Continue per Justins instructions.

Priorities 1 through 11 are basically all the same priority, should be considered urgent and will require call outs for maint issues.

- 1) D-1795 NAQ - East Pfaudler/#3P&S Dryer/#3RC
- 2) Reduction Towers, specifically QVAM on Tower 6 and screening of E-406 TR
- 3) Cu-5020 P then 1520 Solution - HC-11 Tanks
- 4) 1506 then 1520 - PK/#5 RC/Trimer
- 5) D-5206 - Safety/Abbe/National Dryer/#4RC
- 6) Celanese Trial - West Pfaudler/HC-11 dryer & #6 RC
- 7) Al-3921 T 3/16 - Harrop Kiln
- 8) Al-3917 T 3/16 - Horne Tabletting
- 9) Cu-0860 E 1/16 3F - #2 MED/#2 RC
- 10) Al-3917 Pill Mix - PK Blender, as needed to supply Al pill mix to the Hornes
- 11) Clean up and change over on #1MED/#1 RC